

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>154300</u> Part No. <u>DS1 9448-011</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐				
Date : <u>16/12/12</u>		Step #: <u>110</u>		QTY Effective : <u>1</u>		MRB (QSI042) Approval <u>DAS</u> <u>12</u> <u>9-89</u> <u>16/12/12</u>		
Description Work Order Deviation <u>DS1 parts list incorrect on DS1, typo.</u>				Disposition <u>Pick D3749-1, not D3749-3</u>				Completed By <u>16.12.12</u> Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						
		OTHER : _____						

Work Order ID 154350

Friday, December 09, 2016 10:29:17 AM

154350

Page 2

Item ID: DSI 9448-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Upgrade

Start Date: 12/12/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/13/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9448-011 Location: <u>Fg 123</u>								
140		0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89DAS
28
9-89

DEC 13 2016

DEC 14 2016

DAS
21
9-89

DEC 15 2016 DEC 16 2016

VS

16/12/13

DAS
21
9-89

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
85 85 85								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 154350

154350

Parent Item: DSI 9448-011

DSI 9448-011

Parent Item Name: Hinge Upgrade

Start Date: 12/12/2016

Required Date: 12/13/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3748-1 *D3748-1* Hinge Half		Manufactured	No			110	Each	16.0000	3 **	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				16					
					103063			16					
D3749-1 *D3749-1* Hinge Half		Manufactured	No			110	Each	8.0000	3 **	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				8					
					102810			8					
D3723-1 *D3723-1* Bushing		Manufactured	No			110	Each	23.0000	6 **	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST052				23					
					86294			23					

DAS 28 9-89
6
9-89
DEC 12 2016
DAS 27 9-89

DAS 28 9-89
6
9-89
DEC 12 2016
DAS 27 9-89

DAS 28 9-89
6
9-89
DEC 12 2016
DAS 27 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Picklist Print

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Page 2

Work Order ID: 154350

154350

Parent Item: DSI 9448-011

DSI 9448-011

Parent Item Name: Hinge Upgrade

Start Date: 12/12/2016

Required Date: 12/13/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-20A Purchased No

110

Each

104.0000

3

3

AN4-20A

Bolt

**

1x B136148

Location

Loc Qty

Loc Code

GA

6

m116419

6

over003

60

m136148

60

ST343

38

m135966

38

DEC 12 2016

DAS
6
9-89

DAS
27
9-89

AN4-22A Purchased No

110

Each

65.0000

1

1

AN4-22A

Bolt

**

DEC 12 2016

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

50

116419

50

ST342

15

123348

15

AN4-24A Purchased No

110

Each

58.0000

1

1

AN4-24A

Bolt

**

DEC 12 2016

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST342

3

M126175

3

ST343

55

128403

55

Friday, December 09, 2016 10:29:23 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By 					
				Lead hand / Supervisor Approval Verification 					
				QC / QA Coordinator Approval 					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Friday, December 09, 2016 10:29:23 AM

Page 3

Work Order ID: 154350

154350

Parent Item: DSI 9448-011

DSI 9448-011

Parent Item Name: Hinge Upgrade

Start Date: 12/12/2016

Required Date: 12/13/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

3,254.000

8

8

NAS1149D0463.J

Washer

DEC 12 2016

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

GA	80	
M134508	13	
M135056	67	
ST260a	1200	
M136192	600	
M136263	600	
ST263	1974	
M135671	3	
M135948	371	
M136044	1600	

AN970-4

Purchased

No

110

Each

94.0000

4

4

AN970-4

Washer

DEC 12 2016

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST260a	50	
m135390	0	
m136044	50	
ST321	44	
m135600	44	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, December 09, 2016 10:29:23 AM

Page 4

Work Order ID: 154350

Parent Item: DSI 9448-011

Parent Item Name: Hinge Upgrade

154350

DSI 9448-011

Start Date: 12/12/2016

Required Date: 12/13/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

2,651.000

5

5

MS21042L4

Nut

**

DAS 6 27
9-89 9-89
DEC 12 2016

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

196

m135058

196

OVER007

1500

m136182

500

m136295

1000

ST303

937

153851

16

m135864

421

m135979

500

NAS43DD4-46N

Purchased

No

110

Each

72.0000

3

3

NAS43DD4-46N

SPACER

**

DAS 6 27
9-89 9-89
DEC 12 2016

Location

Loc Qty

Loc Code

ST551

72

111886

48

125578

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-540 REV. I

REF CANADIAN STC: SH94-5

REF FAA STC: SR00386NY

REF GERMAN STC: LBA RC 1124

THIS DART SERVICE INSTRUCTION PROVIDES GUIDELINES TO REPLACE THE EXISTING HINGE PLATES WELDED ON THE BASKET BASE AND LID OF D206-540-011/-013 HELI-UTILITY-BASKET AT CHG 004/CHG 005 RESPECTIVELY WITH D3748-1 AND D3749-1 HINGE HALVES TO ELIMINATE POSSIBLE INTERFERENCE BETWEEN THE BASKET INSTALLATION AND THE CABIN DOOR.

REPLACEMENT PROCEDURE:

- 1) REMOVE PROP ARM FROM LID AND SEPERATE LID FROM BASE.
- 2) TRIM HINGE PLATES FLUSH TO LID/BASE FRAME AS SHOWN IN FIGURE 1. DEBURR.
- 3) REMOVE PAINT IN AREAS WHERE THE NEW D3748-1 (BASE) AND D3749-1 (LID) HINGE HALVES WILL BE WELDED. REFER TO VIEWS A-A AND B-B.
- 4) LOCATE QTY(3) D3748-1 ON BASE AS SHOWN IN VIEW A-A AND TIG WELD PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L FILLER ROD.
- 5) POSITION AND CENTER LID ON BASE. SHIM LID BY 0.200". REFER TO VIEW B-B.
- 6) LOCATE QTY(3) D3749-1 ON LID AS FOLLOWS: CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON BASKET BASE ASSEMBLY AND TIG WELD PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L FILLER ROD. REFER TO VIEW B-B.
- 7) TRANSFER DRILL Ø0.261" HOLE FROM D3748-1 TO D3749-1. DEBURR. REFER TO VIEW D-D.
- 8) TOUCH UP PAINT/AFFECTED REPAIRED AREAS ON BOTH LID AND BASE WITH ONE COAT OF MIL-P-85582 OR MIL-P-23377 PRIMER AND 2-3 COATS OF MIL-C-85285 POLYURETHANE PAINT TO MATCH ORIGINAL FINISH.
- 9) INSTALL LID ON BASE IN ACCORDANCE WITH FIGURE 2.
- 10) REFASTEN PROP ARM TO LID.

PARTS LIST:

Qty -011	Part No.	Description
X	DSI 9448-011	HINGE UPGRADE KIT
3	D3748-1	HINGE HALF
3	D3749-3 1	HINGE HALF
6	D3723-1	BUSHING
3	AN4-20A	BOLT
1	AN4-22A	BOLT
1	AN4-24A	BOLT
8	AN960JD416	WASHER
4	AN970-4	WASHER
5	MS21042L4	NUT (OR MS21042-4)
3	NAS43DD4-46	SPACER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.02.12

CERT. NO.: SH94-5

ISSUE NO.: 4

A	NEW ISSUE	MB	09.02.12
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9448	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE UPGRADE KIT	NTS
DATE	09.02.12	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Work Order ID 154350

Friday, December 09, 2016 10:29:17 AM

154350

Page 1

SHIP DEC 14th

Item ID: DSI 9448-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Upgrade

Start Date: 12/12/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/13/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: VS Date: 12/12/16 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9448	REV A								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP DSI 9448-011								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

DEC 13 2016

DAS
21
9-89

DEC 12 2016